



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBT400315-3
Job Sheet 173357



Part No: RBT400315-3

Job Qty: 2 ea

Part Name: Arm



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/28/18

Job Tracking No:

Due Date: 3/16/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBT400315 Rev 0 IPP Rev A 18.02.28 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Start up Operation	2 Ea		3/15/18	0.00	0.00	Start Up Waterjet2		DC 18/04/04
110	Waterjet	2 pcs		3/15/18	0.00	0.20	Waterjet 2 OMAX		DC 18/04/04
120	QC	2 pcs		3/15/18	0.00	0.00	QC2 Waterjet-2		DC 18/04/04
130	QC	2 pcs		3/15/18	0.00	0.00	QC8-6		EB
140	Small Fab	2 pcs		3/15/18	0.00	0.40	Small Fab-3		SB DAS
150	QC	2 pcs		3/15/18	0.00	0.00	QC5		38
160	Mill Conv	2 pcs		3/16/18	0.00	0.40	Mill Conv 2		JB 18-05-07
170	QC	2 pcs		3/16/18	0.00	0.00	QC2 Machining-4		JB 18-05-07
180	QC	2 pcs		3/16/18	0.00	0.00	QC8 Machining-1		18/05/08
190	Packaging	2 pcs		3/16/18	0.00	0.00	Packaging3		CL
200	QC21-SA	2 Ea		3/16/18	0.00	0.00	QC21		DAS MAY 09 2018

Part Op 100 -

Descriptions: 110 - 1-Cut as per Dwg Dwg Rev: 0 Prog Rev: 0 2-Deburr if necessary

140 - 1-Form as per DWG.

160 - Drill holes as per DWG.

170 - Engrave T/N and/or P/N number using Marktronic engraver as per DWG.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MT-HRS-P-0.250	Hot Rolled Steel Plate 0.250" (44W)	.0500 ft (.025 ea)	100-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Start up Operation	MT-HRS-P-0.250	0	0	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
Dart Aerospace Ltd. 1270 Aberdeen Street Hewkebury, ON K8A 1K7 CANADA TEL.: 1 813 832-5200 Email: sales@dartaero.com www.dartaero.com Date: 04/21/18 Container No: S063396 Part: RBT400315-3 Job No: 17357 Serial No/Batch: S063396 Revision: 0 Inspector: _____			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	Process Improvement ☐ Manufacturing Process ☐ Past Due ☐ wave/Twist in Tube ☐ Marks/Chatter ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ OTHER : _____				
Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐					

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

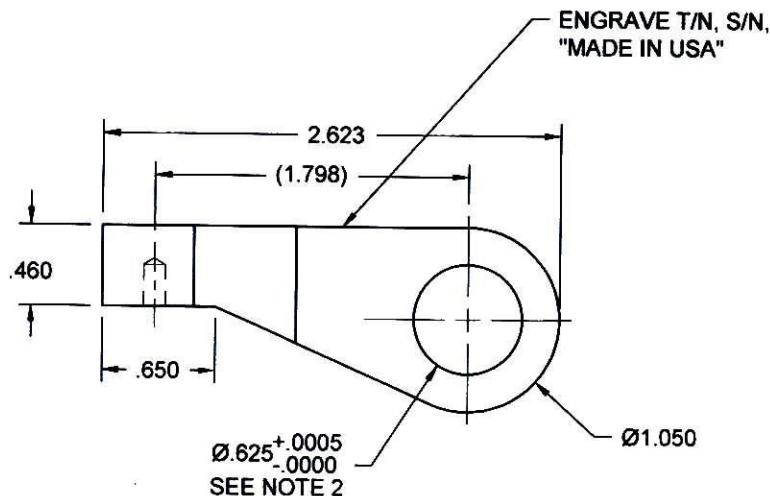
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Work Order update only ☐

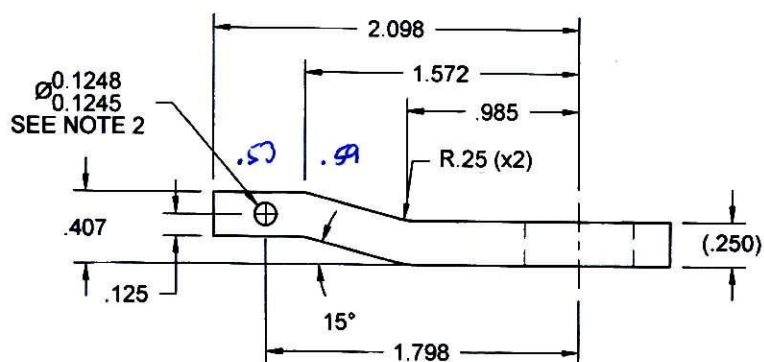
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REVISIONS			
REV	DESCRIPTION	DATE	INITIAL
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SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 17335
19-02-28



(-3)
ARM

NOTES

1. LASER CUT OUTER PROFILE AND FORM.
2. CREATE HOLE FEATURES AFTER FORMING.

RED BARN MACHINE	
TITLE MAIN XSMN BACKLASH TOOL	
DWG NO. RBT400315-3	REV
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
TOLERANCES ON:	DRAWN BY: CLOUGH
DECIMALS:	APPROVED: <i>D. Wed</i>
XXX ± .005	HEAT TREAT
XX ± .01	FINISH
X ± .1	SEE WELDMENT
	SPEC
UNLESS OTHERWISE SPECIFIED	
1. BREAK ALL SHARP EDGES	
.015 x 45° PR .015 R	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE NTS	DATE 1-11-11
SHEET 3 of 5	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

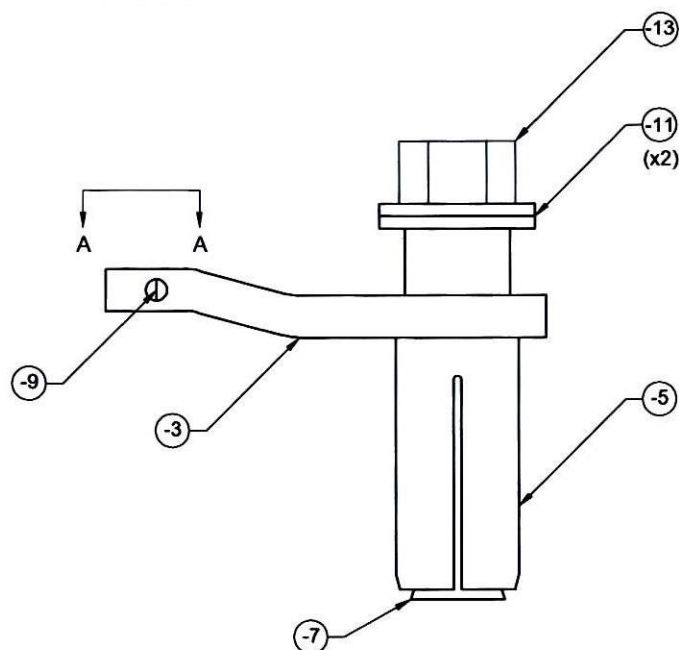
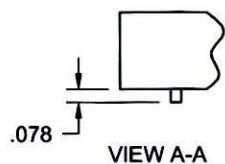
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REV	DESCRIPTION	DATE	INITIAL
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ASSY QTY	B/O	PART #	UNIT QTY	DESCRIPTION	MATERIAL	B/O INFORMATION OR SPECIFICATIONS	Pg.
1		-1	1	WELDMENT			2
1		-3		ARM	A36 PLATE	1/4 x 1-1/8 x 2-7/8	3
1		-5		COLLET	4140 Q&T	Ø3/4 x 2-1/4	4
		-7	1	BOLT	STEEL	7/16-20 UNF -2A MCMaster-CARR #91247A326 (NEEDS MOD.)	5
	B/O	-9	1	DOWEL PIN	STEEL	Ø1/8 x 5/16 MCMaster-CARR #98381A216	1
	B/O	-11	2	FLAT WASHER	STEEL	15/32 I.D. x 59/64 O.D. x .05 MCMaster-CARR #91083A032	1
	B/O	-13	1	HEX NUT	STEEL	7/16-20 UNF -2B MCMaster-CARR #94846A520	1
ASSY -1							

RED BARN MACHINE	
TITLE MAIN XSMN BACKLASH TOOL	
DWG NO. RBT400315	REV
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXX ± .005 FRACTIONS 1/32 ANGLES ± 5° METRIC REF. .XXmm ± .1mm FRACTIONS 1/32 ANGLES ± 5°	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE NTS	DATE 1-11-11
SHEET 1 of 5	